

Work Order ID 52888

October 19, 2009 8:08:14 AM

Page 1

Item ID: DSK081

Accept

Revision ID: A

Item Name: D2940-1 TURNING DETAIL

Start Date: 10/19/2009 Start Qty: 10.00

Required Date: 10/26/2009 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 09-10-19 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSK081

Rev A

100

0.00



MORI SEIKI CNC LATHE LARGE

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA079

09.10.19

10

φ

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

09.10.19

10

φ

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

09/10/20

10

φ

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 52888

October 19, 2009 8:08:14 AM

Page 2

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Required Date: 10/26/2009 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

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Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Packaging

Memo

Identify and Stock in Kanban Location: CL

0.00

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Cust Item ID:

Customer:

09-10-20

10

09/10/20

MF 09-10-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

October 19, 2009 8:08:13 AM

Page 1

Work Order ID: 52888



Parent Item: DSK081RevA



Parent Item Name: D2940-1 TURNING DETAIL

Start Date: 10/19/2009

Required Date: 10/26/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D6104-007RevB

Manufactured No

Each

20.0000

10.0000



Round Billet, 17-4

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

20

38212

9

39627

1

47934

10

09.10.19

10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|---|--------|---------------------|
| DART AEROSPACE LTD | | Work Order: 52888 |
| Description: Turning Detail for D2940-1 | | Part Number: DSK081 |
| Inspection Dwg: DSK081 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| Lathe Section | | | | | | | | |
| A | 3.211 | 3.216 | | 3.214 | 3.214 | 3.214 | 3.214 | 3.214 |
| B | 4.946 | 4.966 | | 4.954 | 4.954 | 4.954 | 4.954 | 4.954 |
| C | 0.718 | 0.738 | | .728 | .728 | .728 | .728 | .728 |
| D | 0.090 | 0.110 | | .100 | .100 | .100 | .100 | .100 |
| E | 3.564 | 3.584 | | 3.574 | 3.574 | 3.574 | 3.574 | 3.574 |
| F | 0.022 | 0.042 | | .032 | .032 | .032 | .032 | .032 |
| G | 3.444 | 3.464 | | 3.454 | 3.454 | 3.454 | 3.454 | 3.454 |
| H | 0.112 | 0.132 | | .122 | .122 | .122 | .122 | .122 |
| I | 2.170 | 2.190 | | 2.180 | 2.180 | 2.180 | 2.180 | 2.180 |
| J | 4.451 | 4.471 | | 4.461 | 4.461 | 4.461 | 4.461 | 4.461 |
| K | 0.413 | 0.433 | | .423 | .423 | .423 | .423 | .423 |
| L | 0.913 | 0.933 | | .923 | .923 | .923 | .923 | .923 |
| M | | | | | | | | |
| N | | | | | | | | |
| O | | | | | | | | |
| P | | | | | | | | |

Measured by: *[Signature]* Date: 09.10.19

Audited by: *[Signature]* Date: 09/10/20

Prototype Approval: Date:

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|---------------------------|--------------------|
| A | 08.04.22 | New Issue | KJ/JLM <i>[Signature]</i> | <i>[Signature]</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | |
|---|--------|---------------------|
| DART AEROSPACE LTD | | Work Order: 52886 |
| Description: Turning Detail for D2940-1 | | Part Number: DSK081 |
| Inspection Dwg: DSK081 | Rev: B | Page 1 of 1 |

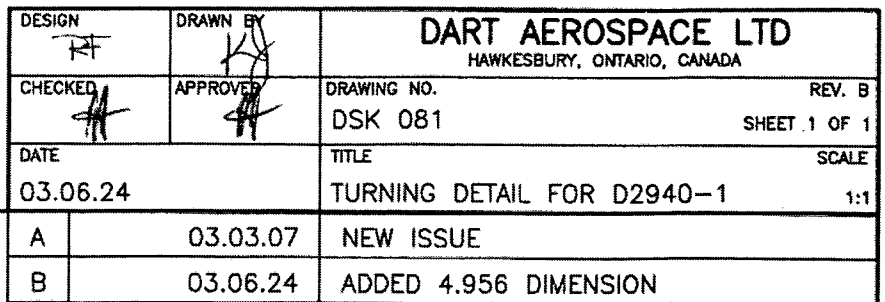
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

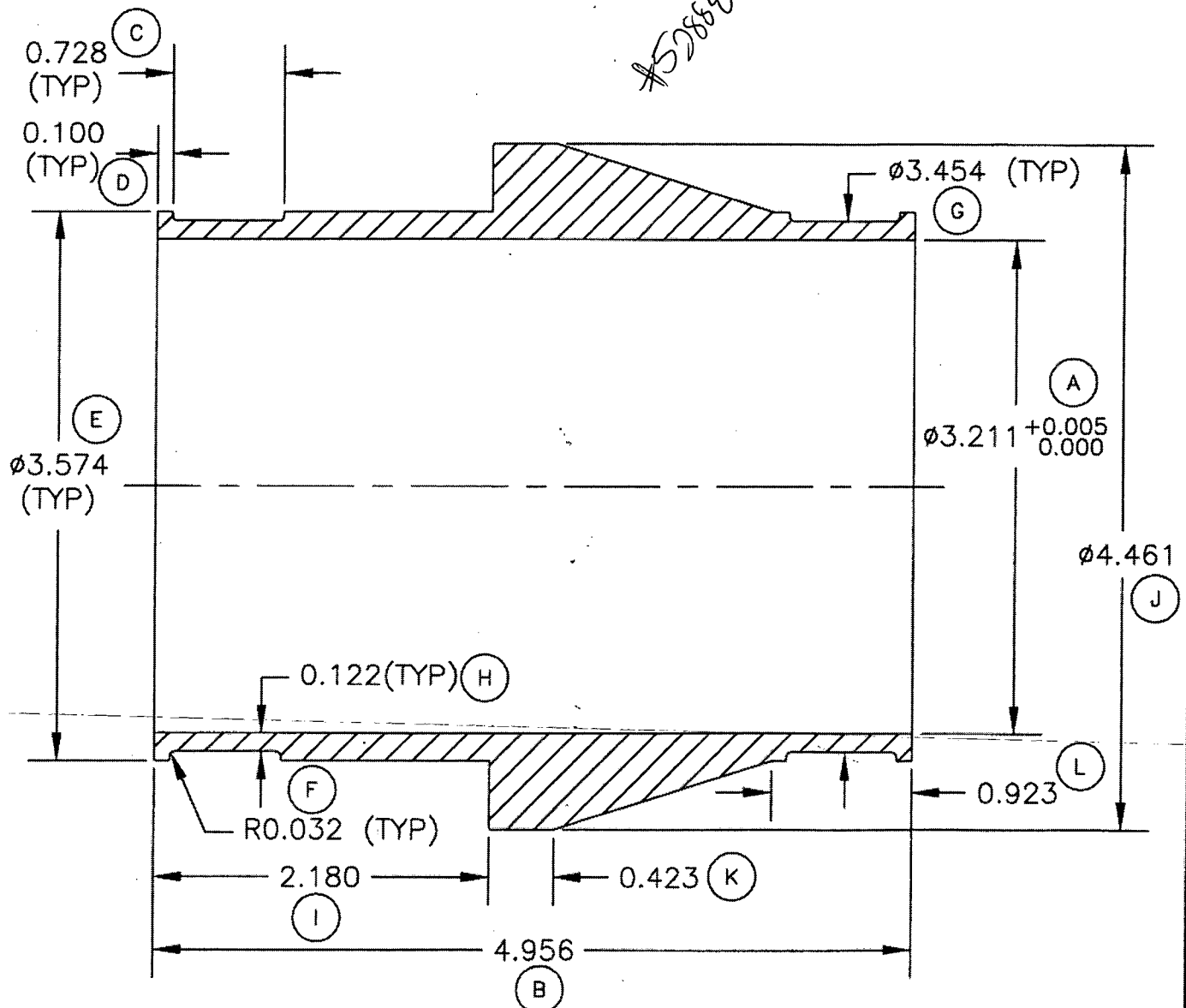
| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| Lathe Section | | | | | | | | |
| A | 3.211 | 3.216 | | 3.214 | 3.214 | 3.214 | 3.214 | 3.214 |
| B | 4.946 | 4.966 | | 4.954 | 4.954 | 4.954 | 4.954 | 4.954 |
| C | 0.718 | 0.738 | | .728 | .728 | .728 | .728 | .728 |
| D | 0.090 | 0.110 | | .100 | .100 | .100 | .100 | .100 |
| E | 3.564 | 3.584 | | 3.574 | 3.574 | 3.574 | 3.574 | 3.574 |
| F | 0.022 | 0.042 | | .032 | .032 | .032 | .032 | .032 |
| G | 3.444 | 3.464 | | 3.454 | 3.454 | 3.454 | 3.454 | 3.454 |
| H | 0.112 | 0.132 | | .122 | .122 | .122 | .122 | .122 |
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| J | 4.451 | 4.471 | | 4.461 | 4.461 | 4.461 | 4.461 | 4.461 |
| K | 0.413 | 0.433 | | .423 | .423 | .423 | .423 | .423 |
| L | 0.913 | 0.933 | | .923 | .923 | .923 | .923 | .923 |
| M | | | | | | | | |
| N | | | | | | | | |
| O | | | | | | | | |
| P | | | | | | | | |

| | |
|---------------------------------|----------------|
| Measured by: <i>[Signature]</i> | Date: 09.10.19 |
| Audited by: <i>[Signature]</i> | Date: 09/10/20 |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|--------------------|
| A | 08.04.22 | New Issue | KJ/JLM | <i>[Signature]</i> |



RELEASED
03-07-01



D2940-1 TURNING DETAIL

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|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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NOTE: Date & initial all entries